

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012150**Date Inspected:** 02-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

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|------------------------------------|---------|---------------------|-----|----------------------------------|-----|----|-----|
| CWI Name: | NA | CWI Present: | Yes | No | | | |
| Inspected CWI report: | Yes | No | N/A | Rod Oven in Use: | Yes | No | N/A |
| Electrode to specification: | Yes | No | N/A | Weld Procedures Followed: | Yes | No | N/A |
| Qualified Welders: | Yes | No | N/A | Verified Joint Fit-up: | Yes | No | N/A |
| Approved Drawings: | Yes | No | N/A | Approved WPS: | Yes | No | N/A |
| | | | | Delayed / Cancelled: | Yes | No | N/A |
| Bridge No: | 34-0006 | Component: | OBG | | | | |

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

Outside Yard: SEG 9AE

Notification No: 005165.

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT reports for this date. The members are identified as OBG Component (SEG 9AE). The weld designations reviewed are as follows:

- 1) SEG050A – 001, 002, 004, 005 & 006.
- 2) SEG050 – 010.

The following weld did not appear to comply with the applicable contract documents:

- 1) SEG050A – 003.

One (1) longitudinal indication was discovered measuring approximately 15mm in length, and at depth of 12mm. The db rating is seen as +07, the material thickness is 16mm. The Weld is a Complete Joint Penetration (CJP) butt weld joining SP582A & SP622A. The “X” & “Y” location of the indication is observed as -5mm & 1700mm respectively & the indication is clearly marked on the weld. The material is designated as Non Seismic

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Performance Critical Member (Non - SPCM).

This QA informed ZPMC Quality Control (QC) identified as Mr. Zhong Wei and American Bridge Fluor (ABF) QA identified as Mr. Wang Chau of this issue and that an incident report would be generated.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Wadkar,Sailesh | Quality Assurance Inspector |
| Reviewed By: | Hall,Steven | QA Reviewer |
